

Work Order ID 68597

Monday, April 18, 2011 11:14:49 AM

Page 1

Item ID: D3741-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 4/18/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3741

Rev B

100

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-drill holes as per dwg D3741-2-Deburr

J.F.S. 11-04-18

4 ϕ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

J.F.S. 11-04-18

4 ϕ

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

J.F.S. 11/04/19

4 ϕ

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 4/18/2011 Start Qty: 4.00

Required Date: 4/22/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

1- Grind radius as per dwg D3741-2- Debur if necessary

*Just 11.04.18.**4*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*A**11.04.19**(4)*

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

- Ad Malo 19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

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Page 3

Item ID: D3741-1

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Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 4/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 11 04 19 (4)

170

Identify as per dwg & Stock Location WA

0.00



Packaging

Memo

0.00

Packaging

11 11 19 5 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11 11 19 19

11 11 04 19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 11:14:47 AM

Page 1

Work Order ID: 68597



Parent Item: D3741-1



Parent Item Name: Angle


Start Date: 4/18/2011

Required Date: 4/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:
IPP Rev:B 08-03-19 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207  Angle Extrusion		Manufactured	No			110	f	0.0000	0.0625	0.263158			



M6061 76 A1.000W.125

~~1718147~~ 7/11/04-18
m115776

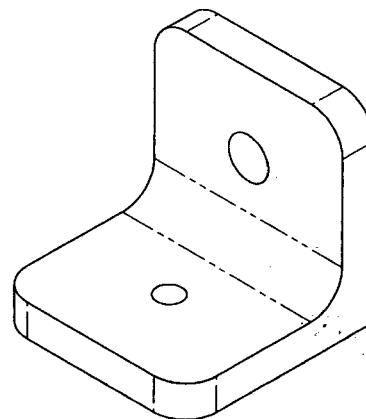
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries



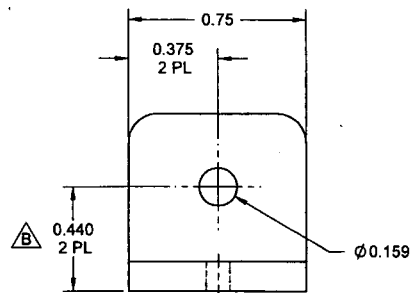
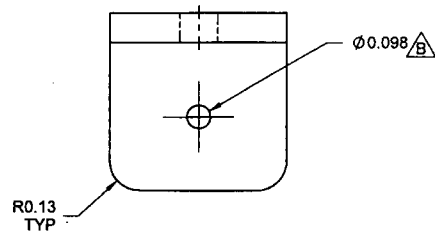
D3741-1 ANGLE

u/o 68597

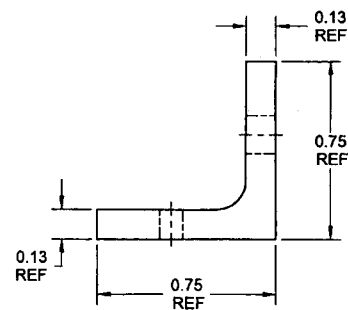
NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	CE	DRAWING NO.	REV. B	
MFG. APPR.	IS	D3741	SHEET 1 OF 2	
APPROVED	JP	TITLE	SCALE	
DE APPR.	JP	ANGLE	NTS	
DATE	08.03.06		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3741-1 ANGLE



68597

1000174P

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	AS	D3741	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ANGLE	NTS
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